Work Orde Monday, January				*111	1716*						Page 1	
Revision ID:	D3451-3 Tube Handle A	лш		Accept	*N900	<u>0</u> 40	100)* s	etup Sta		S1* S2*	
	1/20/2014 1/24/2014	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item :	ID:				ıv	. 12	
Approvals:	Process Plan	n:	Date: 14-1-20	Tooling: _ SPC (Y/N):		ate:		R	tun Sta	/\\ q	R1* R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	-
Draw Nbr	Revi	sion Nbr										_
D3451	Rev	A										
*100 *100* Waterjet FLOW CNC Waterje	et	FLOW WATER JET Memo 1-Cut as per Deburr if ne	· · · · · ·	0.00 0.00 A Prog Rev:	2-			24	6		Ac 14.0	91.22
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00					اربع	/	Λ	
110 QC Quality Control		Memo		0.00				24	9		Ae 14.0	1.22
					DAS					·		

0.00

QC8- Inspect parts - second check

Memo

120

120

Quality Control

DQA:			Date:											7	
			.			WORK ORDER NON	-CC	ONFO	RMANCE / U		147-	.l. 0d		_	AEROSPACE
QA Closed:			Date:				_	Γ	· ·		wo	rk Order up	date only	ł	
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	-					Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	ヿ	Prod	d. Eng. Coor.	7	Quality
	•					Use-as-is]	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
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Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	\perp	QC Inspector
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		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			\vdash	Part Incorred	<u> </u>	┥	emperature/Cure
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	Wave/Twist in Tube			Fit/Function		Out of Sequence									

Work Order ID 111710	rk Ord	der .	II)	Ш	:71 (
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111716 Page 2 Monday, January 20, 2014 1:55:56 PM Accept **Item ID:** D3451-3 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Tube Handle Arm *24* **Start Qty: 24.00 Start Date:** 1/20/2014 **Cust Item ID: Required Date: 1/24/2014** Req'd Qty: 24.00 *24* **Customer:** Reference: Start Run Date: _____ **Tooling:** Approvals: Process Plan: Date: Stop Date: SPC (Y/N): Date: QC: Reject Sequence ID/ Set Up/ **Tool ID** Tool # Plan Operation Accept Reject Insp. Number Stamp Description Qty Qty **Work Center ID Run Hours** Code Identify as per dwg & Stock Location: <u>Wezzz</u> 0.00 130 24× 28 /4-0/-22 *120* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 140 MLJ 1401-2 *140* QC 0.00Memo Quality Control

DQA:		Date:										TRACT
		. .			WORK ORDER NON	-CC	NFO	RMANCE / UI				AEROSPACE
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i -	Crimp/Ki	nk/Rinnle	/\/\ave	-	Burrs		ł	ion Incomplete/Ui	ngualified	Part Lost/M	 	Weld
-	Cuffs	ilk/ Kibbie	:/ vvave		Contamination	\vdash	•	tions Incomplete/U	· —	Part Moved		Wrong Stock Pulled
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-	Heat Tre			-	Cut Too Short		Mislab		-	Power Loss/		Other
-	Inspection		Tube	-	Drawing	-	Misrea		<u> </u>	· · · · · · · · · · · · · · · · · ·		
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H:/FORMS/Qualit				O RevH	•				~		-	

~Pickfist Print

Monday, January 20, 2014 2:12:14 PM

Work Order ID:

111716

Parent Item:

D3451-3

Parent Item Name:

Tube Handle Arm

Start Date: 1/20/2014

Required Date: 1/24/2014

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP Rev:A 08-06-18 new issue DD verified by:

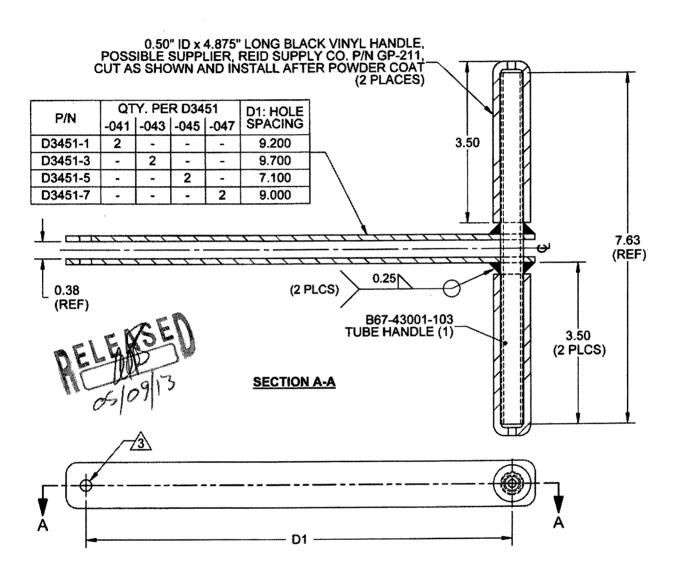
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No				sf	201.7900	<u> </u>	1.7712	Ac	14.0	1. 23
				Location		Loc Qty	Loc	c Code					
		•		MAT021		201.79							
				m127	272	39.5							
				m127	454	130.29			127	7454	\rightarrow	1.8	*
				m127	501	32							

Page 1

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / UP					AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only	
Work Orde	r:					DISPOSITION				AGAINST (DEF	PARTMENT	/PROCESS	
	-					Rework	1 I		Skid-tube	Crosstube			Water Jet	Engineering
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	1			•
DESIGN	\$	DRAWN BY	DART AEROS HAWKESBURY, OI	
CHECK	ED 	APPROVED	DRAWING NO. D3451	REV. A SHEET 1 OF 2
DATE	05.	08.25	HANDLE & LOCK-	SCALE DOWN ASS'Y 1:2
 Α		05.08.25	NEW ISSUE	



D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y

D3451-041 SUPERSEDES PREMIER P/N B67-43001-41 D3451-045 SUPERSEDES PREMIER P/N B67-43001-39 D3451-047 SUPERSEDES PREMIER P/N B67-43001-55

NOTES:

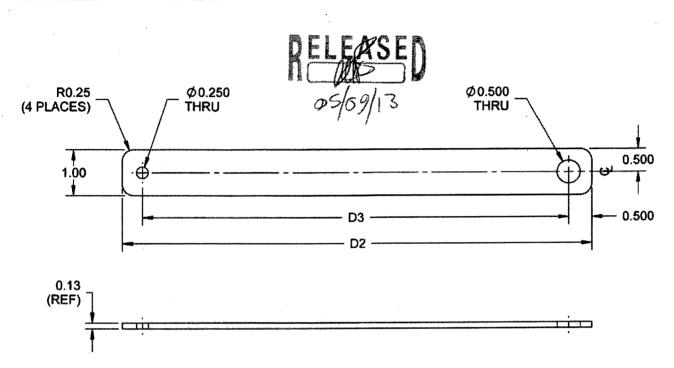
- 1) WELD PER DART QSI 004
- CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK BEFORE PAINTING.
- FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 7) ALL DIMENSIONS ARE IN INCHES
 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DQA:			Date:			-			_				TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				AEROSPACE
QA Closed:			Date:								ork Order up	date only	
Work Orde	or.					DISPOSITION	.			AGAINST D	EPARTMENT	/PROCESS	
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Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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Root				<u> </u>	Desci	ription of work order update		nitial	Action		Sign &	\/ - = :£: - = 4: - =	OC luon actor
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		Bending				Bend	Г	Folio/F	Program	Γ	Outside Dim	ensions	Pressure/Forced
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	┢	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci 📙	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing	Weld
		Cuffs	, ,,			Contamination		•	tions Incomplete/U	<u> </u>	Part Moved		Wrong Stock Pulled
	Г	Crushing				Countersink		4	gned/off center		Positioned V	Wrong	-
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		Inspectio	n Strip in	Tube		Drawing		Misrea	d	_			
		Marks/Cl				Drill Holes		Off-set					
Ì		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tuk	oe	Fit/Function			Out of	Sequence				



1	1		
DESIGN	DRAWN BY	DART AERO HAWKESBURY, C	DSPACE LTD DNTARIO, CANADA
CHECKED	APPROYED.	DRAWING NO.	REV. A SHEET 2 OF 2
DATE 05.	.08.25	TITLE HANDLE & LOCK	SCALE -DOWN ASS'Y 1:2



P/N	D2: CUT LENGHT	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

D3451-1/-3/-5/-7 TUBE HANDLE ARMS

D3451-1 SUPERSEDES PREMIER P/N B67-43001-303 D3451-5 SUPERSEDES PREMIER P/N B67-43001-301 D3451-7 SUPERSEDES PREMIER P/N B67-43001-101

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T680.125)
2) PART IS SYMETRICAL ABOUT CENTER LINE.
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

5) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ar.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
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Part N	lo.					Scrap		1	Machining Small Fab	\vdash	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1		noforming Finishing	, 	4	e/Packaging	Other
NCR I	۱o. ₋					Suspected Unapproved			Large Fab Composite	:]	Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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DART AEROSPACE LTD	Work Order: B111716
Description: TUBE HANDLE ARM	Part Number: D3451-3
Inspection Dwg*p3451 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	+1- ,010	_" 500			✓	JKm~05
,500_	+1010	,500			V	
1.00	-1- ,030	(,00			✓	
10.63	+1- ,030	10.63			Τ	JKm-06
9.700	+1- 1010	9.700			T	
.125	+1- ,010	.121			V	
\$.250	+.0051001	,250			V	
	+.006/001	, SUO			V	
				_		
L				DAS		

Measured by:	Audited by: 27 9-89	Preliminary Approval:
Date: 14.01.22	Date: 14-01-72.	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15

